



Dart Aerospace Ltd.
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April 27

D3239-1
Job Sheet 175150

Part No: D3239-1

Job Qty: 10 ea

Part Name: Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev: A New Issue 05-11-06 JLM IPP: b 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/26/18	0.00	0.00	Start Up Waterjet		DL 18/04/08
100	Waterjet	10 pcs		4/26/18	0.00	0.20	Waterjet1		DL 18/04/08
120	QC	10 pcs		4/26/18	0.00	0.00	QC8		ES
130	Small Fab	10 pcs		4/26/18	0.00	0.00	Small Fab-3		
140	HandFinish	10 pcs		4/27/18	0.00	0.68	HandFinish1		SA 18/04/08
150	QC	10 pcs		4/27/18	0.00	0.00	QC7-2		11 APR 11 2018
160	Packaging	10 pcs		4/27/18	0.00	0.00	Packaging3	5/027	APR 11 2018
170	QC21-SA	10 Ea		4/27/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3239

Descriptions: 130 - Deburr if necessary.

21
9-80

APR 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.050	6061-T6 .050 Sheet	1.8000 sf (.18 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.050	2	108	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cover	5.000inches ± 0.030	5.030 4.970		
2	Cover	0.050inches ± 0.005	0.055 0.045		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effect: _____		MRB (QSI042) Approval	
Description Work Order Deviation:				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

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Container No: S059066

Part: D3239 - 1

Job No: 175150

Serial No/Batch: S059066

Date: 04/08/18

Inspector:

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Crushing ☐

Heat Treat ☐

Wave/Twist in Tube ☐

Marks/Chatter ☐

incomplete/Unqualified ☐

Contamination ☐

Countersink ☐

Cut Too Short ☐

Instructions Incomplete/Unclear ☐

Drill Holes ☐

Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐
Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐
Finish ☐	Misread ☐	Turning Sequence ☐				

OTHER : _____